

Date: Thursday, 10/25/2007 10:05:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 35360		Part Number	: D35341	
Estimate Number	: 12524		Drawing Number	: D3534 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/25/2007	S.O. No. : N/A	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/8/2007	
Previous Run	: 34785		Qty:	8	
Written By	: <u>JK</u> 10/25		Um:	Each	
Checked & Approved By					
Comment	: Est Rev:A New Issue 07-09-24 EC verified by DD				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		Comment: Qty.: 0.2048 sf(s)/Unit Total : 0.8190 sf(s) 2024-T3 .050 sheet Batch: <u>105646</u> <u>B 07-10-30</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3534 Dwg Rev: <u>A</u> <u>B 07-10-30</u>
		2-Deburr if necessary <u>B 07-10-30</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 07-10-30</u>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <u>B 07-10-30</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>B 07-11-01</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:05:48 AM
User: Kira Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35360

Part Number: D35341

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-11-01

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 108



07/11/02 NS



(9)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

Job Completion



u 07.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

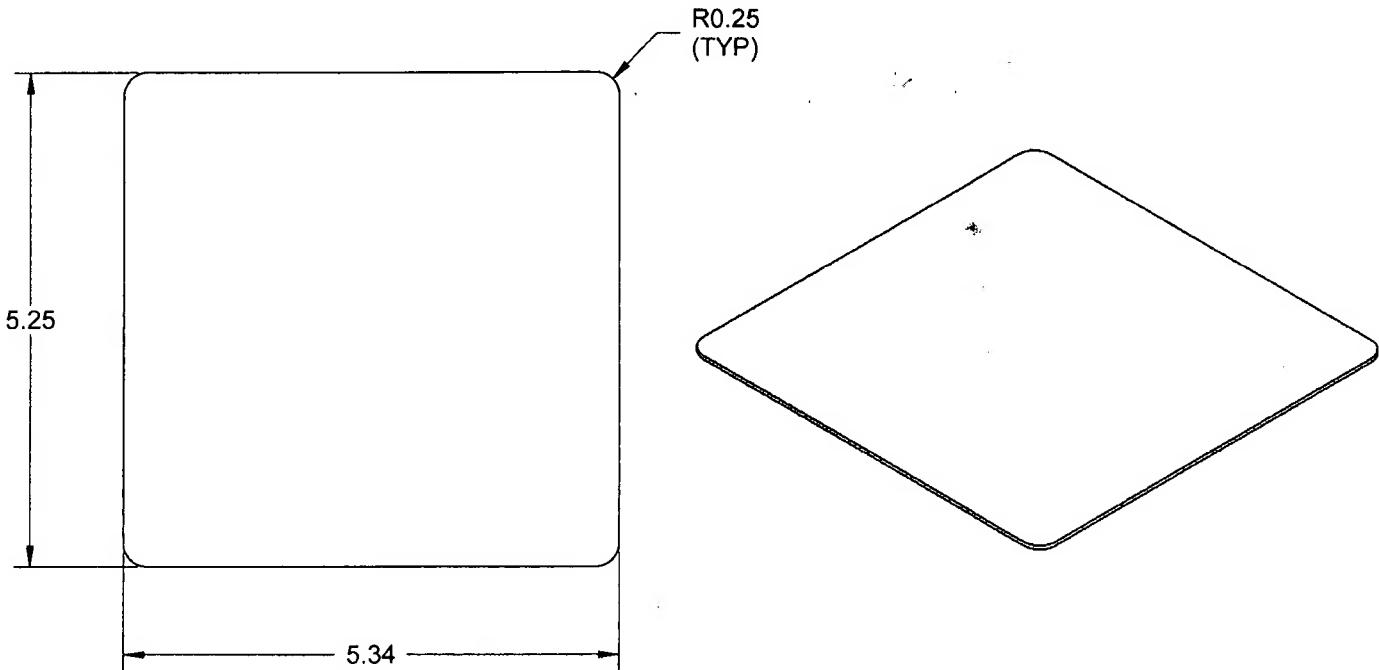
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3534	REV. A	SHEET 1 OF 1
DATE 07.01.10		TITLE DOUBLER	SCALE	1:2
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE		

RELEASED
07.08.03**D3534-1 DOUBLER****NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3534-1" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *35360*

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DART AEROSPACE LTD	Work Order:	35360
Description: Doubler	Part Number:	D.3534-1
Inspection Dwg: D3534 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>IB</u>	Audited by: <u>SG</u>	Prototype Approval: <u>✓</u>
Date: <u>07-10-30</u>	Date: <u>07/10/30</u>	Date: <u>✓</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	